

69.

5/29

DART AEROSPACE LTD	Work Order:	23689
Description: Lug	Part Number:	D2591
Drawing: D2591 Rev. D	Qty:	100 99

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	7/1	05.06.27	100
2	METAL	Cut blanks: 2.700" long Material: ASTM A36 steel bar 2.50" X 0.75" thick Batch: <i>m178900</i>	5	05.07.12	100
3	HAAS	Machine per Folio FA039 <i>m17664</i>	SD	05.07.12	99
4	QC	Inspect Level 2	SD	05.07.13	99
5	QC	Inspect Level 8	EC	05.07.13	99
6	METAL	Tumble	N/A		
7	METAL	Deburr after tumbling if necessary	SD	05.07.13	99
8	QC	Inspection Level 5	EC	05.07.13	99
9	STORES	Identify and Stock	11	05.07.13	99
10	EXPEDITING	Close W/O <i>5.69</i> Inspection Level 21 Cost/part: <i>5.69</i>	11	05.07.15	99
			11	05.10.14	99

P70V

EC

Rev	Date	Change	Revised By	Approved
C	98.01.21	Changed Rev of Dwg	BW	
D	98.04.17	Re-format	KB	
E	99.07.06	Re-format, Added bevel	DM	
F	99.09.14	Remove bevel, added tumble	EC	
G	00.03.15	Now goes on Haas	EC	
H	01.11.29	Reformat	SM	EC

RELEASED

UNDER REVIEW

03.06.05 RF

EC 01.11.30

combine with

D205-641-010

ADD 9161

Ref 04.12.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-07-13	6	Remove permanently		05-07-14	N/A		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.07.12	3	part came out of use		destroy		05.07.12		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 05/07/14

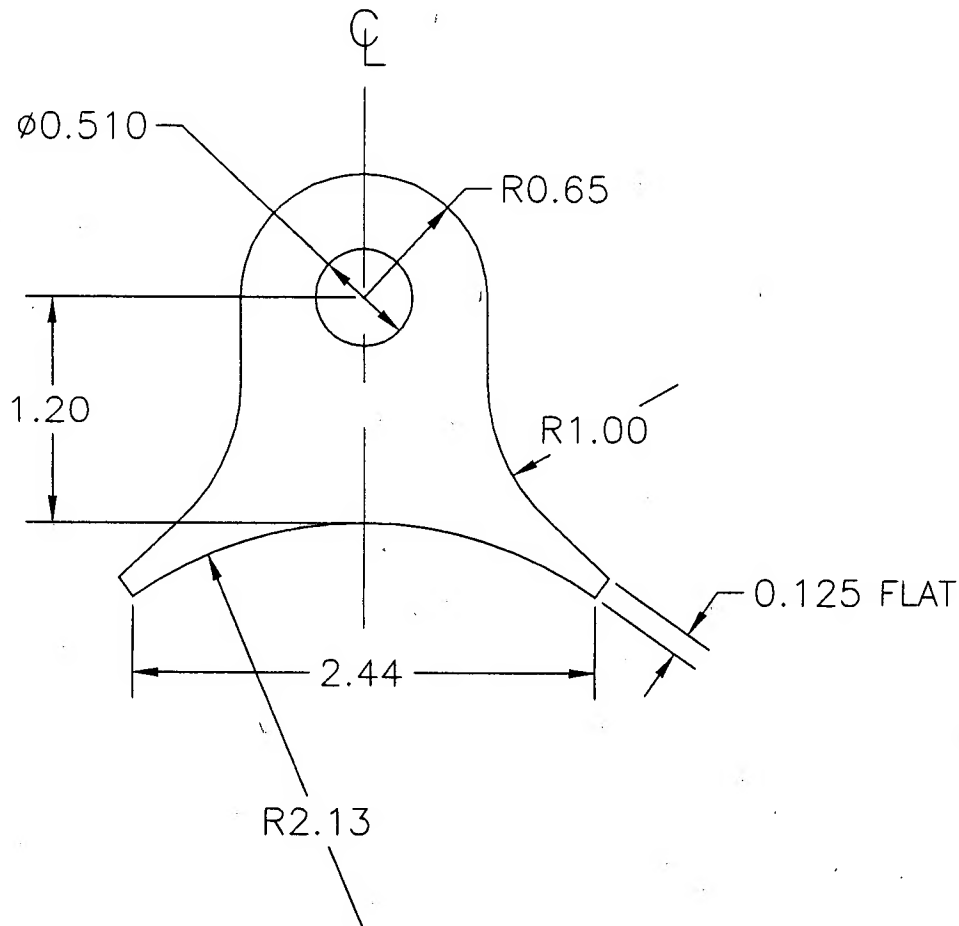
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>MEY</i>	DRAWN BY <i>MEY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BS</i>	DRAWING NO. D259.1	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
48.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO 23689

1. 5. 2.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 27, 2005
08:10 am

Work Order No : 0023689
Project Name : D2591
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D2591
Description : Lug
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 06-27-05
Est Finish Date : 07-25-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

